Work Order ID 66488 Page 1 Wednesday, February 16, 2011 7:43:01 AM Item ID: D3396-3 Accept Setup Start **Revision ID:** Stop Item Name: Spacer **Start Qty: 30.00 Start Date:** 2/16/2011 **Cust Item ID:** Req'd Qty: 30.00 Required Date: 2/18/2011 **Customer:** Reference: Start Run Date: Tooling: **Approvals: Process Plan:** Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description Qty Number Stamp **Run Hours** Code **Qty Draw Nbr Revision Nbr** D3396 Rev B 100 0.00 Hardinge CNC LATHE SMALL Hardinge 0.00 Memo ' Hardinge CNC Lathe Small Turn as per Folio FA514 and Dwg D3396 □ Deburr 11)2/24 110 QC2- Inspect parts off machine FAI/FAIB 0.00 40 \$ 0.00 Memo Quality Control Sh 11/2/24

120

QC8- Inspect parts - second check

0.00

Al 11.2-24 40 0

40 6

1 100(10) 1(0(1) 1(0)() 00()() QC

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Memo

0.00

Quality Control

### **Dart Aerospace Ltd**

W/O:	•		WO	RK ORDER CHANGE	ES			
DATE	STEP	PRO	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								1
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Resc	olution:	Disposition	n:	QA: N/C Cl	osed:	Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NCR	)		
DATE	STEP	Description of NC		Corrective Action Section B			n Approval	Approval
	Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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#### Work Order ID 66488

Wednesday, February 16, 2011 7:43:01 AM



Page 2

Item ID:

D3396-3

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Spacer

**Start Date:** 

Required Date: 2/18/2011

2/16/2011

**Start Qty: 30.00** 

Req'd Qty: 30.00



**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

Approvals:

QC: \_\_\_\_

Process Plan:

Operation

Description

Date:\_ Date:\_\_\_ Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

Date: Date:

Tool # Plan

Code

Accept

Qty

Stop



Sequence ID/ **Work Center ID** 

Packaging

Memo

Packaging

0.00

0.00

140

OC

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Run

Start

Reject



Reject Insp. Number Stamp

## **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA	١:	Date:	
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	₹)			
B.47-	0	Description of NC	Description of NC Correct			Verific	Verification		Approval
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign of Date	Section C		Approval Chief Eng	QC Inspector
								<u> </u>	

#### **Picklist Print**

Wednesday, February 16, 2011 7:42:58 AM

Work Order ID: 66488

Parent Item: D3396-3

Parent Item Name: Spacer



**Start Date: 2/16/2011** 

Required Date: 2/18/2011

Page 1

**Start Qty: 30.00** 

Required Qty: 30.00

Comments:

IPP A□05.10.03□New issue□KJ/JLM□

	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	~ .	Date Issued	Status
MDELRINR0.750		Purchased	No			110	f	63.8900	0.0625	1.973684	. 1	~ l ·	

Delrin Round Bar 0.75"

Loc Qty	Loc Code	
13.634		
13.634		·
50.256		
0.12		<u> </u>
50.136		1.3Kt
	13.634 13.634 50.256 0.12	13.634 13.634 50.256 0.12

# **Dart Aerospace Ltd**

W/O:			. <b>W</b> (	ORK ORDER CHANG	ES					
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1.2.2			-							
					,					
Part No	:	PAR #:	Fault Cate	gory:	_ NCF	R: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
	R	esolution:	Dispositio	n:	_ QA:	N/C CId	sed:		Date:	
NCR:		1	WORK ORD	ER NON-CONFORMA	NCE	(NCR	)			
DATE	STEP	Description of NC	Corrective Action Section			Sign &	Verific	cation		Approval
DAIL	SILF	Section A	Initial Chief Eng				Sect	tion C Chief Eng		QC Inspector
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					4					

DART AEROSPACE LTD	Work Order:	1488
Description: Spacer	Part Number:	D3396-3
Inspection Dwg: D3396 Rev: B		Page 1 of 1

	FIRS	T ARTICLE II	NSPECTI	ON CHE	CKLIST		
	<u> </u>	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nments
0.226	+/-0.010	.225			Wen	31	1-9
Ø0.313	+0.005/-0.000	0.315				′	•
Ø0.740	+/-0.010	0,741			1		7
0.032 x 45°	+/-0.010	.030X45°					
					·		
					· .		
			-				
Measured by: Date: 2	1/2/24	Audited by: Date:	pf /1.2	. 24	Prototype	Approval: Date:	N/A N/A
Rev         Date           A         06.03.09	Change New Issue				F	Revised by	Approved

Dart	<b>Aeros</b>	pace	Ltd

	Johnan								
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	R	esolution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCI	7)			
DATE	STEP	Description of NC		V			Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
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						-	, <del>1</del> , (7, -1)		

<sup>.</sup> H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



DESIG	CP	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	KED J.,	APPROVED 4/1	DRAWING NO.	REV. B
	#	卅	D3396 SHEET	1 OF 1
DATE		M	TITLE	SCALE
05.0	14.27	·	SPACER	2:1
Α		05.03.10	NEW ISSUE	
В		05.04.27	ADD -3	



Ø0.740 O.D. 0.226 -0.032×45° CHAMFER (TYP)\_ DRILL 'F' (Ø0.257 REF, -1 SPACER)
DRILL 'O' (Ø0.316 REF, -3 SPACER)

#### D3396-1/-3 SPACER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:			WO	RK ORDER CHANG	ES				****	
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Part No	:	PAR #:esolution:	Fault Cateo	gory:	_ NCR: Y	es N	o DQA	<b>\:</b>	·	·
NCR:				R NON-CONFORMA			- * *			
DAŤĒ	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Si	gn & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
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